

Date: Wednesday, 5/31/2006 7:36:27 AM  
 User: Kim Johnston

## Process Sheet

|  |                                     |
|--|-------------------------------------|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                                  | <b>Drawing Name</b> : ARM           |
| <b>Job Number</b> : 27288  |                                     |
| <b>Estimate Number</b> : 11375   |                                     |
| <b>P.O. Number</b> : N/A   | <b>Part Number</b> : D33871         |
| <b>This Issue</b> : 5/31/2006 <b>S.O. No.</b> : N/A                                    | <b>Drawing Number</b> : D3387 REV A |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A         |
| <b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS                                  | <b>Drawing Revision</b> : A         |
| <b>Previous Run</b> : 27104  | <b>Material</b> : N/A               |
| <b>Written By</b> : <i>See comment below</i>   | <b>Due Date</b> : 6/15/2006         |
| <b>Checked &amp; Approved By</b> : <i>06.05.31</i>                                     | <b>Qty:</b> 10 <b>Um:</b> Each      |
| <b>Comment</b> : Est:A 05.06.10 New Issue KJ/JLM<br>Est:B 06.03.22 Split c'sink op. EC |                                     |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                    |                         |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0500X06000 | 6061-T6 Bar .50" x 6.0" |
|-----|--------------------|-------------------------|



**Comment:** Qty.: 1.5685 f(s)/Unit Total: 15.6849 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6/T651 (QQ-A-200/8)  
 (M6061T6B0.500x06.000)  
 Identify for D3387-1  
 Batch: *M101092*

*J.F. 06/06/06 (10)*

|     |          |          |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



**Comment:** BAND SAW  
 Cut blank: 6.000" x 0.500" x 17.800" long

*J.F. 06/06/06 (10)*

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA511 and Dwg D3387  
 Identify as D3387-1  
 Tumble and Deburr NO sharp edges

*J.F. 06/06/07 10*

|     |               |                              |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



**Comment:** CONVENTIONAL MILLING MACHINE  
 C'sink Ø0.375" as per Dwg D3387

*J.F. 06/06/07 10*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:36:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27288

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/06/07 10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/06/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PAT

06/06/08 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/06/08 (10)

Job Completion



u 06/06/08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: SD Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                              |               |                     |         |
|------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b>  | 27288   |
| <b>Description: Arm</b>      |               | <b>Part Number:</b> | D3387-1 |
| <b>Inspection Dwg: D3387</b> | <b>Rev: A</b> | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance           | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------------|------------------|--------|--------|----------------------|----------|
| R0.125            | +/-0.010            | R0.125           | ✓      |        |                      |          |
| 0.125             | +0.020/-0.000       | 0.135            | ✓      |        |                      |          |
| Ø0.375 x100°      | +/-0.010            |                  |        |        |                      |          |
| R0.032            | +/-0.010            | R0.032           | ✓      |        |                      |          |
| 0.500             | +/-0.010            | 0.494            | ✓      |        |                      |          |
| 0.500             | +/-0.010            | 0.502            | ✓      |        |                      |          |
| 7.577             | +/-0.010            | 7.574            | ✓      |        |                      |          |
| R0.125            | +/-0.010            | R0.125           | ✓      |        |                      |          |
| Ø0.507            | +0.000/-0.001       | Ø0.5066          | ✓      |        |                      |          |
| 0.250             | +/-0.010            | 0.247            | ✓      |        |                      |          |
| 1.347             | +/-0.010            | 1.347            | ✓      |        |                      |          |
| 2.000             | +/-0.010            | 2.002            | ✓      |        |                      |          |
| 1.000             | +/-0.010            | 1.001            | ✓      |        |                      |          |
| Ø0.191            | +0.005/-0.000       | Ø0.192           | ✓      |        |                      |          |
| R0.300            | +/-0.010            | R0.300           | ✓      |        |                      |          |
| 2.033             | +/-0.010            | 2.032            | ✓      |        |                      |          |
| <del>0.250</del>  | <del>+/-0.010</del> |                  |        |        |                      |          |
| <del>0.232</del>  | <del>+/-0.010</del> |                  |        |        |                      |          |
| 1.700             | +/-0.010            | 1.702            | ✓      |        |                      |          |
| 0.188             | ±.010               | 0.190            | ✓      |        |                      |          |
| 0.300             | ±.010               | 0.301            | ✓      |        |                      |          |
|                   |                     |                  |        |        |                      |          |
|                   |                     |                  |        |        |                      |          |
|                   |                     |                  |        |        |                      |          |

|                     |           |                    |          |                            |     |
|---------------------|-----------|--------------------|----------|----------------------------|-----|
| <b>Measured by:</b> | <i>mf</i> | <b>Audited by:</b> | J.L      | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 06/06/06  | <b>Date:</b>       | 06/06/06 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 05.04.27 | New Issue | KJ/JLM     | <i>[Signature]</i> |

**DART**

| DESIGN                     | DRAWN BY                    | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
|----------------------------|-----------------------------|---|--------------|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO.<br>D3387                              | REV. A       |
| DATE<br>05.01.18           | TITLE<br>ARM                | SCALE<br>1:3                                      | SHEET 1 OF 1 |
| A                          | 05.01.18                    | NEW ISSUE   |              |

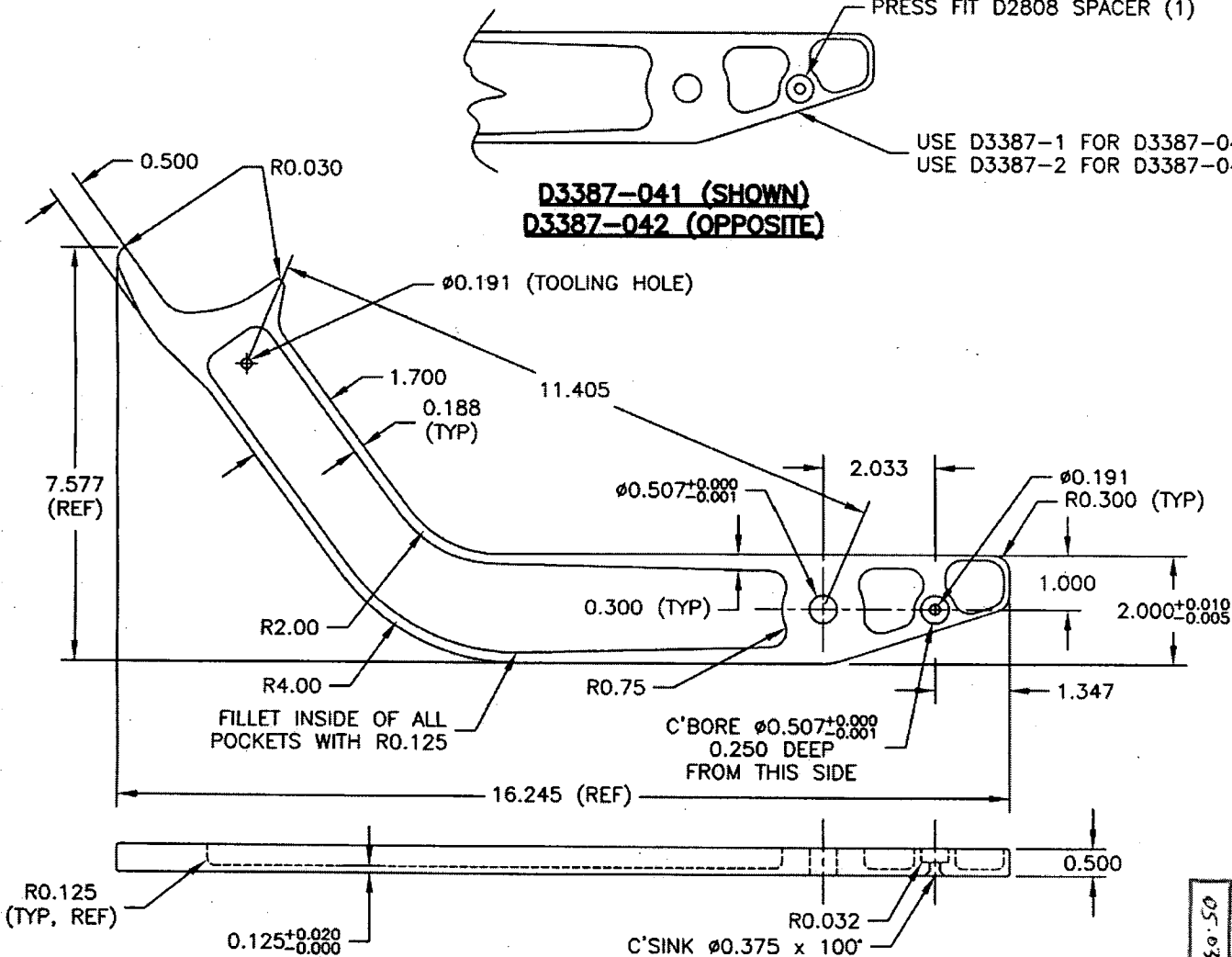
**RELEASED**

05.03.11

PRESS FIT D2808 SPACER (1)

USE D3387-1 FOR D3387-041  
USE D3387-2 FOR D3387-042

**D3387-041 (SHOWN)**  
**D3387-042 (OPPOSITE)**



**D3387-1 (SHOWN)**  
**D3387-2 (OPPOSITE)**

**GENERAL NOTES**

MACHINE PER DRAWING FILE "D3387-A.DWG"  
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK  
(REF DART SPEC. M6061T6B0.500)  
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 27288